



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-C

Job Sheet 191763



Part No: C45-C

Job Qty: 1 pcs

Part Name: Single Cage Assembly (C45 & C60 Hook)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/7/19

Job Tracking No:

Due Date: 4/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-C rev.E IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP IPP REV:B 19.05.02 AS PER DWG REV.E DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Sign-off
100	External Load - Issue SN	1 pcs	4/10/19	4/10/19	0.00 0.00	External Load - 1	S180275
110	External Load - 2 - B4B	1 pcs	4/10/19	4/10/19	0.00 0.50	External Load - 1	AP 2019/05/10
						External Load - 2	
						External Load - 3	
120	QC 5	1 pcs	4/10/19	4/10/19	0.00 0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 42	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
140	Packaging 3-1 - Stock - B4B	1 pcs	4/10/19	4/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	



Dart Aerospace Ltd.
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CANADA
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Container No: S180275



Part: C45 - C

Job No: 191763

Serial No/Batch: S180275

Revision: E

Inspector:

Exp Date:

Instructions:

Date: 05/10/19

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	1 pcs	4/10/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - Issue S/N Descriptions: 110 - (Small Fab)ASSEMBLE AS PER DWG ***HAND TIGHTEN ALL BOLTS, SPREAD COTTER PIN JUST ENOUGH SO THAT IT WILL NOT FALL OUT*** 120 - (QC5- Inspect part completeness to step on W/O) 140 - (Identify as per dwg & Stock Location: _____) 160 - QC21- Final Inspection - Work Order Release)					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN12H32	Bolt	1 pcs (1 ea)	100-External Load - Issue SN	
AN310-12	Castellated Nut	1 pcs (1 ea)	110-External Load - 2 - B4B	
AN8-23A	Bolt	2 Ea (2 ea)	110-External Load - 2 - B4B	
C45-15-10	Ford Bumper	1 pcs (1 ea)	110-External Load - 2 - B4B	
C45-15-11	Nut, Cage Bumper	1 Ea (1 ea)	110-External Load - 2 - B4B	
C45-15-6	Bushing, Lifting	1 pcs (1 ea)	110-External Load - 2 - B4B	
C45-15-7	Washer, Lifting Bolt	4 pcs (4 ea)	110-External Load - 2 - B4B	
C45-18-7	Shim	4 Ea (4 ea)	110-External Load - 2 - B4B	
C45-19C	Weldment	1 pcs (1 ea)	110-External Load - 2 - B4B	
MS21044N8	Nut, Self-Lock .500-20,UNJF-3B	2 Ea (2 ea)	110-External Load - 2 - B4B	
MS24665-363	Cotter Pin	1 Ea (1 ea)	110-External Load - 2 - B4B	
NAS1149C0663R	Washer	1 Ea (1 ea)	110-External Load - 2 - B4B	
NAS1149F0863P	Washer	4 Ea (4 ea)	110-External Load - 2 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
	C45-15-3	0	29	1
Allocated Container Detail				
	Qty	Container No	Location	Init
	1	S167033	ga207	
100-External Load - Issue SN	AN12H32	1	48	1
Allocated Container Detail				
	Qty	Container No	Location	Init
	1	S167029	ga207	
110-External Load - 2 - B4B	AN310-12	1	31	0
	AN8-23A	2	76	2
Allocated Container Detail				
	Qty	Container No	Location	Init
	2	S167030	ga199	
C45-15-10	1	12	1	
Allocated Container Detail				
	Qty	Container No	Location	Init
	1	S167031	ga207	
C45-15-11	1	83	1	

Allocated Container Detail			
Qty	Container No	Location	Init
1	S167032	ga207	_____
C45-15-6	1	11	1
Allocated Container Detail			
Qty	Container No	Location	Init
1	S167034	ga207	_____
C45-15-7	4	77	1
Allocated Container Detail			
Qty	Container No	Location	Init
1	S167035	ga207	_____
C45-18-7	4	34	4
Allocated Container Detail			
Qty	Container No	Location	Init
4	S167036	ga207	_____
C45-19C	1	5	0
MS21044N8	2	50	2
Allocated Container Detail			
Qty	Container No	Location	Init
2	S167037	ga199	_____
MS24665-363	1	84	1
Allocated Container Detail			
Qty	Container No	Location	Init
1	S167038	ga199	_____
NAS1149C0663R	1	504	1
Allocated Container Detail			
Qty	Container No	Location	Init
1	S167039	ga200	_____
NAS1149F0863P	4	730	4
Allocated Container Detail			
Qty	Container No	Location	Init
4	S167040	ga200	_____
Part Specifications			
Specifications could not be found.			

Plex 5/9/19 5:03 PM Dart.Renwick.Jennifer



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*Check
Deviation*

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Job Sheet 191763



Part No: C45-C

Job Qty: 1 pcs

Part Name: Single Cage Assembly (C45 & C60 Hook)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/7/19

Job Tracking No:

Due Date: 4/30/19

Created By: Marie Lajeunesse

Type: ~~SOB~~ *Sold Alone*

Description:

Note: C45-C rev.4 IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	External Load - 1	1 pcs	4/30/19	4/30/19	0.00	0.50	External Load - 1		
							External Load - 2		
							External Load - 3		
120	QC 5	1 pcs	4/30/19	4/30/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Packaging 3-1 - Stock - B4B	1 pcs	4/30/19	4/30/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		

*Amended
see attached.*

Plex 3/7/19 3:08 PM Dart.lajeunesse.marie

					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	1 pcs	4/30/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - (Small Fab)ASSEMBLE AS PER DWG ***HAND TIGHTEN ALL BOLTS, SPREAD COTTER PIN JUST ENOUGH
 Descriptions: SO THAT IT WILL NOT FALL OUT***
 120 - (QC5- Inspect part completeness to step on W/O)
 140 - (Identify as per dwg & Stock Location: _____)
 160 - QC21- Final Inspection - Work Order Release)

Job BOM

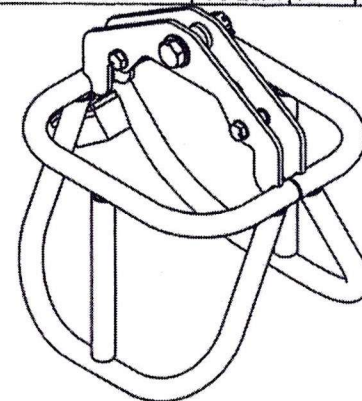
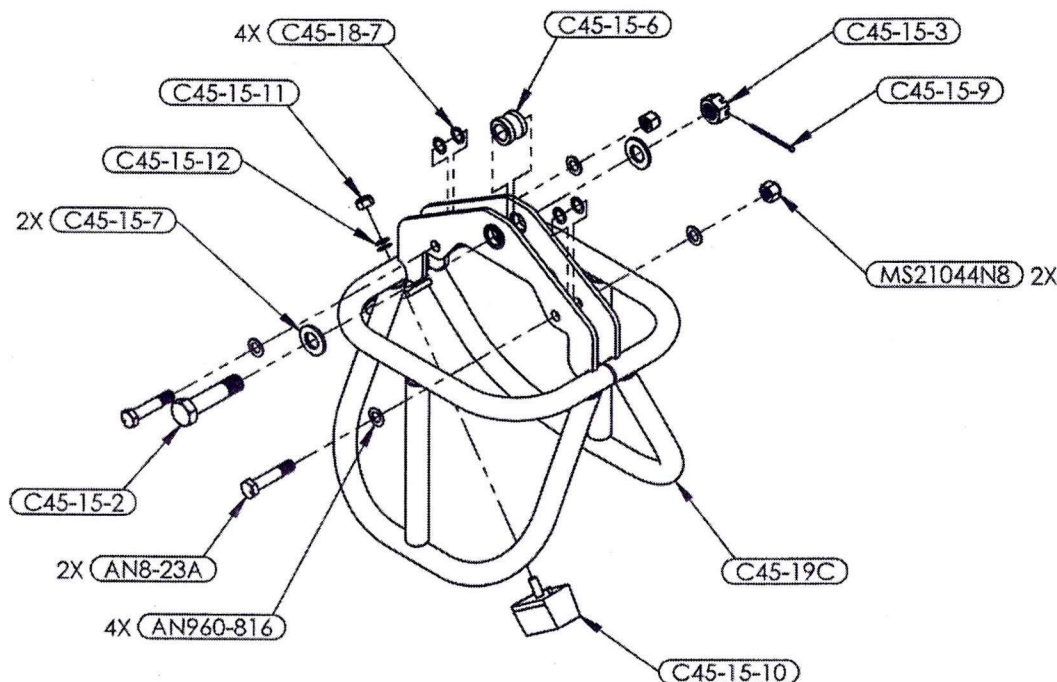
Part / Item	Component Name	Quantity	Operation	Container
AN12H32	Bolt	1 pcs (1 ea)	100-External Load - 1	5097920
AN8-23A	Bolt	2 Ea (2 ea)	100-External Load - 1	5085037
C45-15-10	Ford Bumper	1 pcs (1 ea)	100-External Load - 1	51564255 177794
C45-15-11	Nut, Cage Bumper	1 Ea (1 ea)	100-External Load - 1	5036837
C45-15-3	Lifting Bolt Castle Nut	1 pcs (1 ea)	100-External Load - 1	5036834
C45-15-6	Bushing, Lifting	1 pcs (1 ea)	100-External Load - 1	5067712
C45-15-7	Washer, Lifting Bolt	4 pcs (4 ea)	100-External Load - 1	5113259
C45-18-7	Shim	4 pcs (4 ea)	100-External Load - 1	5054305
C45-19C	Weldment	1 pcs (1 ea)	100-External Load - 1	51667855 177217
MS21044N8	Nut, Self-Lock .500-20,UNJF-3B	2 Ea (2 ea)	100-External Load - 1	5147505
MS24665-363	Cotter Pin	1 Ea (1 ea)	100-External Load - 1	5092509-1
NAS1149C0663R	Washer	1 Ea (1 ea)	100-External Load - 1	5076016-1
NAS1149F0863P	Washer	4 Ea (4 ea)	100-External Load - 1	5058169
AN310-12	NUT	1		5004855
NAS1149F0832P	WASHER	4		5076018

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-External Load - 1	AN12H32	1	27	0
	AN8-23A	2	34	0
	C45-15-10	1	6	0
	C45-15-11	1	87	0
	C45-15-3	1	11	0
	C45-15-6	1	15	0
	C45-15-7	4	53	0
	C45-18-7	4	27	0
	C45-19C	1	0	0
	MS21044N8	2	60	0
	MS24665-363	1	89	0
	NAS1149C0663R	1	534	0
	NAS1149F0863P	4	770	0
Part Specifications				
Specifications could not be found.				

Plex 3/7/19 3:08 PM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		AS DRAWN BY APICAL	11/6/2012	JAG	
4	15-0180	UPDATED TO NEW DRAFTING STANDARDS. CH'D P/N WAS C45-15-8 IS AN960-816. C45-15-4 DELETED, REPLACED WITH AN8-23A. C45-15-5 DELETED, REPLACED WITH MS21044N8. C45-18-7 ADDED TO BOM QTY 4.	7/22/2015	DPD	JAG
E	19-660	Replace B/O Info for C45-15-2, C45-15-3 and C45-15-9, C45-15-12	04/12/2019	M.Lee	ML



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-19C	1	WELDMENT		
			C45-15-2	1	LIFTING BOLT	STEEL	AN12H32
		B/O	C45-15-3	1	CASTLE NUT	STEEL	AN310-12
		B/O	C45-15-7	2X	LIFTING BOLT WASHER	STEEL	3/4 (MCMASTER-CARR #98023A036)
		B/O	C45-15-9	1	COTTER PIN	S.S	MS24665-363
			C45-15-10	1	FORD BUMPER		(#E3TZ-4730-A) MODIFIED
		B/O	C45-15-11	1	CAGE BUMPER NUT	STEEL	M10, CLASS 8 (MCMASTER-CARR #90576A118)
		B/O	C45-15-12	1	CAGE BUMPER WASHER	STEEL	NAS1149C0663R
			C45-15-6	1	LIFTING BUSHING	4140/4142	
		B/O	C45-18-7	4	SHIM	STEEL	.025 X Ø.511 I.D. (MCMASTER-CARR #3088A412)
		B/O	AN8-23A	2	BOLT	STEEL	1/2-20 X 1.47
		B/O	AN960-816	4	LIFTING BOLT WASHER	STEEL	AN960-816 (NAS1149F0863P)
		B/O	MS21044N8	2	NUT	STEEL	1/2-20

DART AEROSPACE	
TITLE C45 CAGE	
DWG NO. C45-C	
REV E	
DRAWN BY: APICAL	
APPROVED: <i>M.Lee</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	
1. BREAK ALL SHARP EDGES .016 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:8	DATE 4/12/2019
SHEET 1 OF 1	

NAS1149F0863P

REPLACE BY 10/05/2019